FAASA - 119 MIRRORS

Dart Aerospace Ltd.

Date: Tuesday, 2/26/2008 8:02:06 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BELL CRANK
Job Number	: 37629		
Estimate Number	: 11967		
P.O. Number	:	**Part Number**	: D2056
This Issue	: 2/26/2008 **S.O. No.** :	**Drawing Number**	: D2056 REV B2
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	: B2
Previous Run	: 31220	**Material**	:
Written By	:	**Due Date**	: 3/14/2008 **Qty:** 8 **Um:** Each
Checked & Approved By	: DF 08 02 26		
Comment	: Est. E. 02.04.04 Added Rev.B2 NG		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"

Comment: Qty.: 0.2494 f(s)/Unit Total : 0.9975 f(s)
6061-T6 Bar 1.25 x 1.25"
Material: 6061-T6, 1.250" x 1.250" Batch: M103220 08/03/07 (8)

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blanks 2.80" long 08/03/07 (8)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per folio D2056
Tumble
Deburr any rough edges after tumbling B.A/JL 08/03/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE B.A/JL 08/03/07

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK DF 08/03/08 (8)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1 08-03-16 x8

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** D **Date:** 08/03/12

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:06 AM
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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BELL CRANK

Job Number: 37629 **Part Number:** D2056

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	POWDER COATING	POWDER COATING

M/00700 FL 08/03/11 (8)

Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

(8X) M-L 08/03/11

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 10 AS 08/03/12 (8)

10.0	QC21	FINAL INSPECTION/W/O RELEASE

(8) DOB 08/03/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion 2008/3/12 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

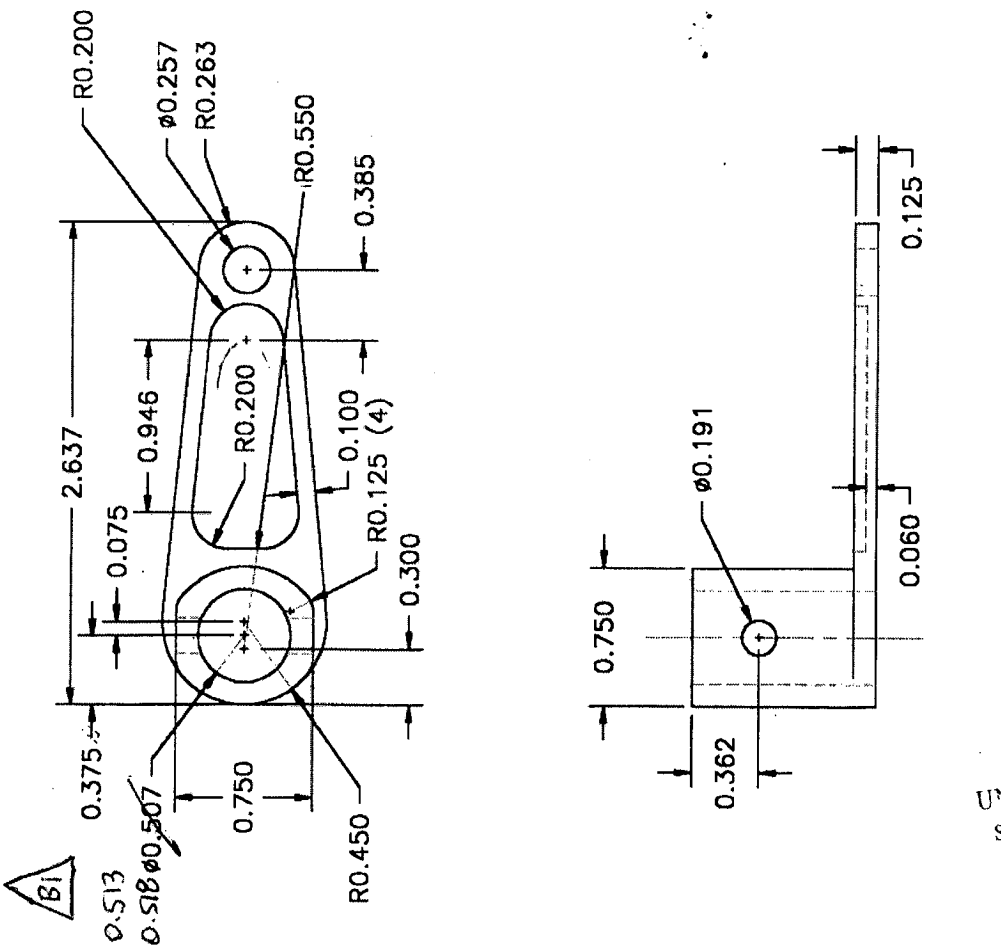
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO. / REV.
BW	KE	D2056 / B
DATE		TITLE / SCALE
92:03:13		BELL CRANK / 1:1

DA COPY ISSUED

RELEASED
99.04.28 KE

B		95:11:02	RE-DESIGN
B1	iP#	01.06.04	MODIFY HOLE SIZE, ADD P/C OPTION
B2	iP#	01.12.20	ADD NOTE ON TOLERANCES



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 37629

DART AEROSPACE LTD	Work Order:	37629
Description: BELL CRANK	Part Number:	D2056
Inspection Dwg: D2056 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/- .010	0.750	✓			
0.900	+/- .010	0.900	✓			
1.000	+/- .010	1.000	✓			
0.125	+/- .010	0.120	✓			
0.060	+/- .010	0.061	✓			
Ø0.191	+0.005/-0.001	Ø0.191	✓			
0.362	+/- .010	0.367	✓			
0.750	+/- .010	0.7515	✓			
0.385	+/- .010	0.386	✓			
Ø0.257	+0.006/-0.001	Ø0.260	✓			
0.100	+/- .010	0.097	✓			
0.300	+/- .010	0.300	✓			
0.946	+/- .010	0.943	✓			
0.750	+/- .010	0.750	✓			
0.075	+/- .010	0.075	✓			
2.637	+/- .010	2.638	✓			
0.375	+/- .010	0.376	✓			
Ø0.513/0.518	0.513 / 0.518	Ø.516	✓			
R 0.450	+/- .010	R 0.450	✓			
R 0.125	+/- .010	R 0.125	✓			
R 0.260	+/- .010	R 0.200	✓			
R 0.550	+/- .010	R 0.550	✓			
R 0.263	+/- .010	R 0.263	✓			

Measured by:	Y.A / [signature]	Audited by:	[signature]	Prototype Approval:	
Date:	08/03/07	Date:	08.03.07	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	